

**केन्द्रीय मुहर विभाग -2**

संदर्भ :- केमूवी-2/16:5872

09 06 2025

**विषय: संशोधित IS 5872:2025 के अनुपालन के दिशा निर्देश**

यह उपरोक्त विषय के संदर्भ में है।

सक्षम अधिकारी द्वारा अनुमोदित दिशानिर्देश अनुपालन हेतु संलग्न है।

सभी क्षेत्रीय/शाखा कार्यालयों से अनुरोध है की दिशानिर्देशों का तत्काल प्रभाव से अनुपालन सुनिश्चित करें।

**रंजीत कुमार  
वैज्ञानिक डी**

**प्रमुख (केमूवी 2)**

**सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/MTD/LRMD**

**CENTRAL MARKS DEPARTMENT-2**

Our Ref: CMD-2/16:5872

09 06 2025

**Subject: Guidelines for implementation of Revised IS 5872:2025.**

This has reference to the subject mentioned above.

The Competent Authority has approved the enclosed Guidelines for implementation.

All ROs/BOs are requested to ensure the implementation of the above Guidelines with immediate effect.

**(Ranjit Kumar)  
Scientist D**

**Head (CMD-2)**

**All ROs/BOs/Labs/MTD/LRMD**

## **CENTRAL MARKS DEPARTMENT-2**

**OurRef:CMD-2/16:5872**

**Date: 09 06 2025**

**Subject: Guidelines for implementation of Revised IS 5872:2025 (Steel strapping for packaging)**

1. IS 5872:1990 has been revised as IS 5872:2025 and has been published. The last date for implementation of the revised Standard is 22<sup>nd</sup> August 2025 after which the old Standard shall stand withdrawn.
2. All BOs shall inform the Applicants and Licensees under their jurisdiction about implementation of the revised Standard within a week of issuance of these guidelines.
3. The significant changes in the revised Standard as listed in the Table below are given for the purpose of general guidance. BOs shall ensure that the product conforms to all the requirements, as applicable, as per the revised Standard.

<b>Clause (s) as per IS 5872:2025</b>	<b>Change</b>
Title	The title of the Standard has been modified from “Cold Rolled Steel Strips (Box Strappings)” to “Steel Strapping For Packaging”
3. Supply of Material	A new clause 3.2 specifying the supply condition “Heat-treated condition”, as required and agreed between the purchaser and the manufacturer/supplier has been added.
5.1 Grade (Table-1 and Annexure-C)	A new grade, ‘Grade 4’ has been included in this revision. The chemical composition and physical properties for Grade 4 have been specified in Table 1 & Annexure-C respectively.
7. Reverse Bend Test Procedure	<p>The clause of reverse bend test has been modified. Earlier the reverse bend test was referred to IS 1403 (Part-1). However, in revised standard the Reverse Bend Test Procedure have been specified in the standard itself. The corresponding number of bends to failure against nominal thickness have also been specified in the revised standard.</p> <p>Further, a note specifying that IS 1403 (Part-1) may be referred for reverse bend test with respect to the dimension other than specified</p>

	in the standard has been added. In such case the minimum number of bends to failure may be mutually agreed between the purchaser and the supplier for the same.
10.1 Nominal Dimensions	The nominal thickness & width have been specified in the revised standard.
10.2 Dimension Tolerances	The requirement of thickness tolerances for thickness more than 1.20mm has been added.
10.3 Shape Tolerance	A new clause 10.3 & Table-7 specifying shape tolerances (Camber, Flatness, Twist) of steel strapping along with method of test have been added
10.4 Weld	A new clause 10.4 specifying the requirement of weld joint strength has been added.
14.1 Marking	<p>Earlier it was specified that <b>“Every coil of strip”</b> shall be marked with the information given in the clause.</p> <p>Clause has been modified to now specify that <b>“Every strip or every package or every box”</b> shall be legibly marked with the information given in the clause.</p>

4. Consequent upon the issuance of the revised Standard, the existing product manual of IS 5872 has been revised which is being circulated separately.

5. The guidelines for implementation of the revised Standard is given below:

**A. LICENSEES:**

i) For switchover to revised standard, Licensees shall submit evidence of conformity to the additional/modified requirements through In-house/Independent Test Reports.

ii) All Licensees shall implement the revised Standard by **22<sup>nd</sup> August 2025**. Any difficulty in implementation shall be brought to the notice of CMD 2 at the earliest but in any case at least 30 days before the last date of implementation. BOs shall ensure that no Licences are under operation as per old Standard after 22<sup>nd</sup> August 2025. The status of implementation of the revised Standard shall be confirmed by Head (BO) to CMD-2 within two weeks of the last date of concurrent running.

iii) BOs shall plan an early surveillance visit for verification of the implementation of the revised standard preferably within 30 days of switchover by the licensee.

**B. APPLICATIONS FOR GRANT OF LICENCE:**

i) Existing Applications where Sample has been submitted in the Laboratory/Test Report has been issued by the Laboratory may be processed as per the old Standard. However, if the Applicant is desirous of considering the Application as per the revised Standard, a declaration may be obtained from the Applicant to that effect and the Application may be processed accordingly. An undertaking shall also be obtained from such Applicants that if the sample fails in new test requirements, Licence will not be granted by BIS as per the old version.

ii) Applications which are recorded henceforth may be processed as per the old Standard or the revised Standard. Processing of Applications as per the old Standard shall be permitted only up to 21<sup>st</sup> August 2025 and for such cases Applicant shall give a declaration that they will implement the revised Standard by 22<sup>nd</sup> August 2025.

iii). Beyond 22<sup>nd</sup> August 2025 no Licence shall be granted as per the old Standard.

**C. CHANGE IN SCOPE OF LICENCE:**

i) For change in scope of licence, the relevant provisions as given above for Applicants shall apply.

ii) However, processing of such applications for change in scope of licence as per the old Standard shall be permitted only up to the date of implementation of the revised Standard or up to 22<sup>nd</sup> August 2025 whichever is earlier.

6. The above guidelines come into force with immediate effect.

**Ranjit Kumar**  
**Scientist-D**

**Head (CMD-2)**  
**DDG(Certification)**  
**Circulated to: All RO/BOs**  
**All other concerned - through BIS intranet**